



Dart Aerospace Ltd.
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D3639-1

Job Sheet 206097



Part No: D3639-1

Job Qty: 12 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/24/20

Job Tracking No:

Due Date: 2/17/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	12 pcs		2/17/20	0.17	0.91	Waterjet - Flow			on 20/01/29
110	QC 2	12 pcs		2/17/20	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			on 20/01/29
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
QC 2 - 8										
QC 2 - 66										
QC 2 - 64										
							Plex 1/24/20 9:16		AM Dart.lajeunesse.mar	

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120 QC 8	12 pcs	2/17/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
130 Small Fab - Brake NC - B4B	12 pcs	2/17/20	0.25 0.57	QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	JAN 30 2020 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 QC 5	12 pcs	2/17/20	0.00 0.00	QC 8 - 76	
				QC 8 - 61	DAS 30 9-89
				Small Fab - Brake - 1 - B4B	JAN 30 2020
150 Handfinish - 1-1 Chemical-B4B	12 pcs	2/17/20	0.00 0.74	Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	FFR 0 3 2020 40 9-89
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	12 pcs	2/17/20	0.00 0.74	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	

				Handfinish - 1 - 3 - B4B	BFB 20-02-08
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	12 pcs	2/17/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
170 Packaging 3-1 - Stock - B4B	12 pcs	2/17/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	DAS
				Packaging 3 - 23 - B4B	84
				Packaging 3 - 24 - B4B	9-89
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
180	QC 21 - SA	12 pcs	2/17/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
					FEB 07 2020

Part Op 100 - 1-Cut as per Dwg - Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - QC7-Inspect Chemical Conversion Coat

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	2.8680 sf (.239 ea)	100-Waterjet - Flow - 1	S237392

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	3	97	0

Part Specifications	
Specifications could not be found.	

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DART AEROSPACE LTD		Work Order: 726097
Description: Doubler		Part Number: D3639-1
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	0.625	1		V. 01-02	
Ø0.191	+0.005/-0.001	0.191	1		Typ	
Ø0.098	+0.004/-0.001	0.098	1			
0.69	+/-0.030	0.688	1			
1.59	+/-0.030	1.591	1			
2.49	+/-0.030	2.495	1			
3.39	+/-0.030	3.384	1			
3.990	+/-0.010	3.985	1			
4.990	+/-0.010	4.991	1			
5.19	+/-0.030	5.191	1			
6.99	+/-0.030	6.99	1			
8.64	+/-0.030	8.639	1			
0.45	+/-0.030	0.451	1			
0.710	+/-0.010	0.711	1			
2.000	+/-0.010	1.999	1			
2.75	+/-0.030	2.749	1			
3.55	+/-0.030	3.552	1			
4.00	+/-0.030	4.000	1			
2.000	+/-0.010	2.000	1			
2.590	+/-0.010	2.591	1			

Measured by: <i>ac</i>	Audited by: <i>40</i>	Prototype Approval: N/A
Date: 20/01/29	Date: JAN 30 2020	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

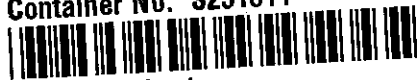
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S251811



Part: D3639-1

Job No: 206097

Serial No/Batch: S251811

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 01/29/20